

Date: Tuesday, 14/10/2008 10:19:16 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y LH		
Job Number	: 42560			Part Number	: D412769043		
Estimate Number	: 13306			Drawing Number	: D412-769-1 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 21/10/2008 Qty: 1 Um: Each		
Previous Run	: 40918						
Written By	:						
Checked & Approved By	: <u>JULIE</u> 08/10/14						
Comment	: Est rev A 08.05.12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec Est Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D3782045	Back Leg Assembly	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg Assembly		
	batch: <u>42152</u>		<i>SP</i>
3.0	D3782041	Front Inboard Leg Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Inboard Leg Assembly		
	batch: <u>42149</u>		<i>FF 08/10/23</i>
4.0	D3782043	Front Outboard Leg Assembly, LH	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Outboard Leg Assembly, LH		
	batch: <u>42150</u>		<i>FF 08/10/23</i>
5.0	D3783041	Lateral Brace Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Lateral Brace Assembly		
	batch: <u>B42725</u>		<i>FF 08/10/23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 10:19:16 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B 42640

FF 08/10/23

(D)

7.0 D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B 42551

8/10/21

SLP

8.0 D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: 42641

FF 08/10/23

(D)

9.0 D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: 42519

SL

10.0 D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: 42521

SL

11.0 D37661

Front Rail, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B 40863

SL

12.0 D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B 40865

OK

8/10/21

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: M10866

SL

14.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M10868

8/10/21

SL

15.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109013

FF 08/10/23

①

16.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M10890

SD

17.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

SD

18.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0363J) batch: \_\_\_\_\_

SD

19.0 AN960JD416 Washer



SD

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108827

(or NAS1149D0463J) batch: \_\_\_\_\_

8/10/21

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 10:19:17 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD516	Washer
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M1090S9

(or NAS1149D0568J) batch:

SL

21.0	AN52510R24	Screw
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108879

SL

22.0	MS21042L3	Nut
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M109037

SL

23.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108845

SL

24.0	MS21042L5	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108827

SL

SD

25.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/10/24

①

26.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SD 08/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 14/10/2008 10:19:17 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

27.0 POWDER COATING

POWDER COATING



M 106442



(X)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when powder coating

3- Powder coat remainig of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:00 =  
01

OVEN TEMPERATURE:

320  
8:30

FINISH TIME:

M 08/10/25

28.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/10/27

29.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0 D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

~~Note~~

Seat Belt Eye Bolt

batch: B42563

FF 08/10/29

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: B40869

scf

32.0 D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B41084

8/10/21

scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq.#: Machine Or Operation:

Description :

33.0 D37743 Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40868

SD

34.0 AN525 10R22 Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M109267

SP

35.0 AN960JD10L Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M104885

(8) (5)  
batch: (or NAS1149D0332J) batch: M105793

SD

36.0 MS21042L3 Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M109031

SD

37.0 AN35A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

8/10/21

SB

38.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-1

FF 08/10/27

39.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

40.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: P0042983

AS 08/01/2008

41.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

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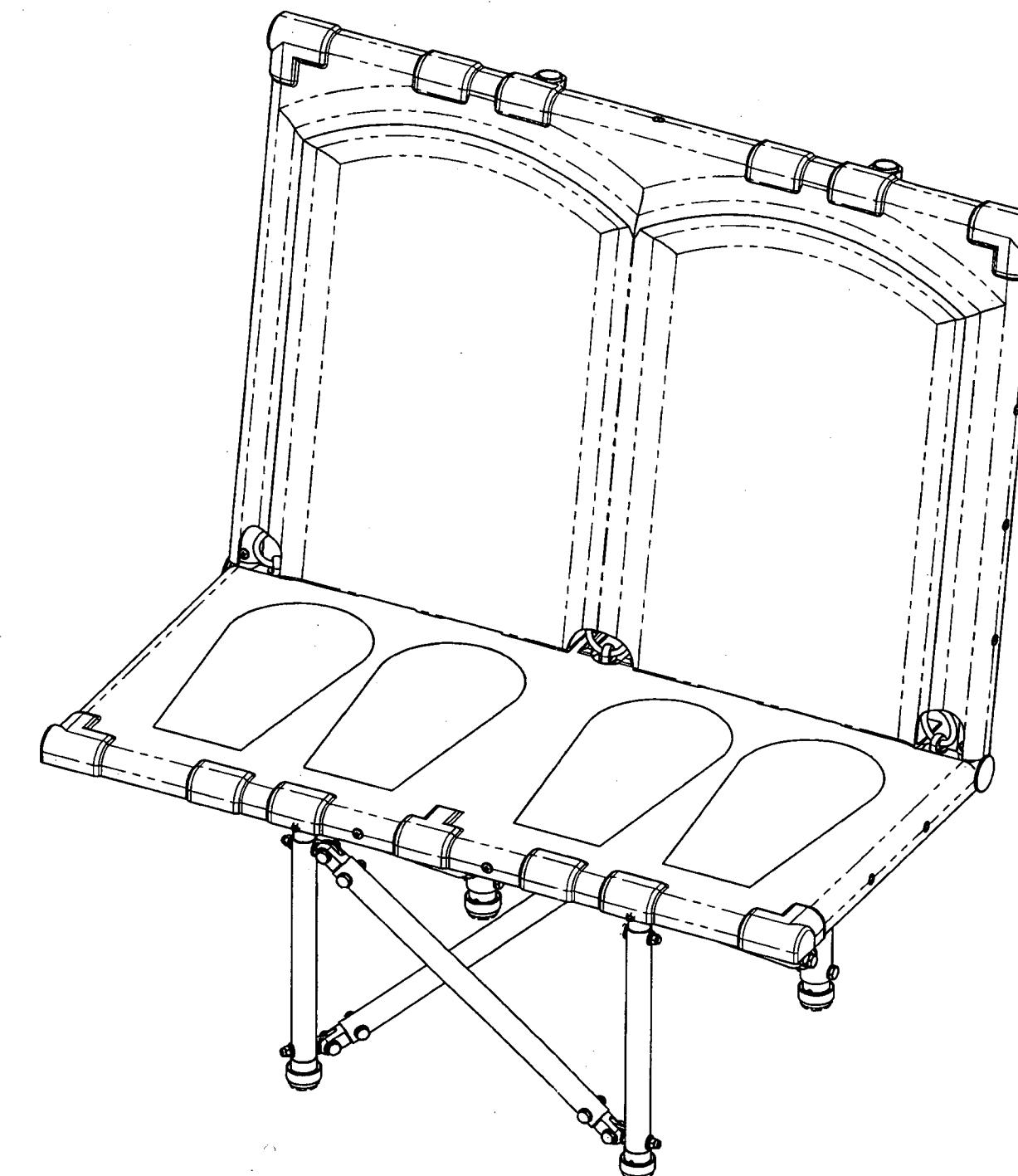
C

B

B

A

A



D412-769-043 AFT FACING SEAT ASSY, LH

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P.A.	DRAWING NO.	REV. B
MFG. APPR.	A.M.	D412-769-1	SHEET 1 OF 7
APPROVED	T.W.	TITLE	SCALE
DE APPR.	N/A	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
58-07-09  
NO. 4250

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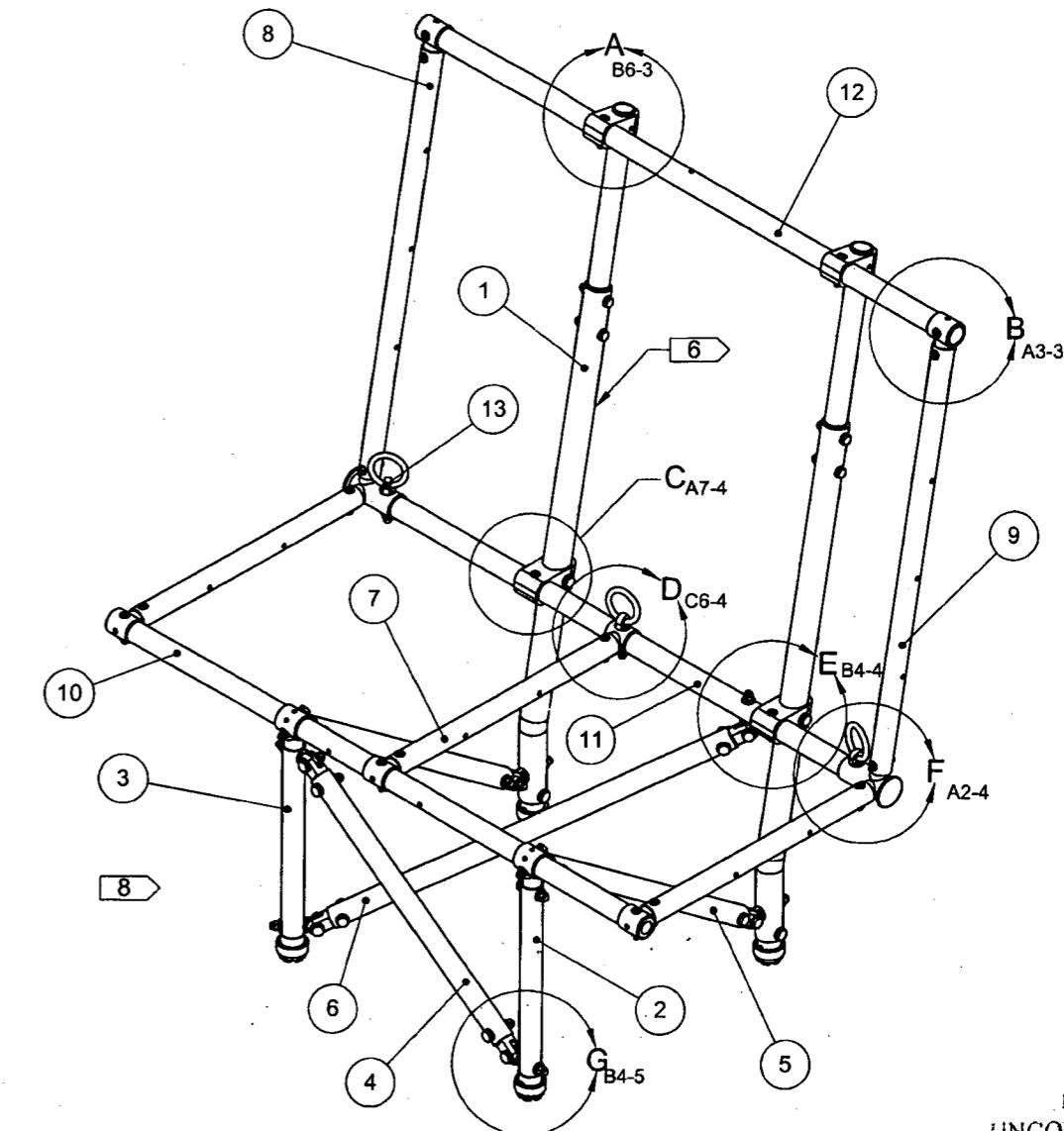
1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B  
B

D

D



D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED  
08.07.09  
42560

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42560

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

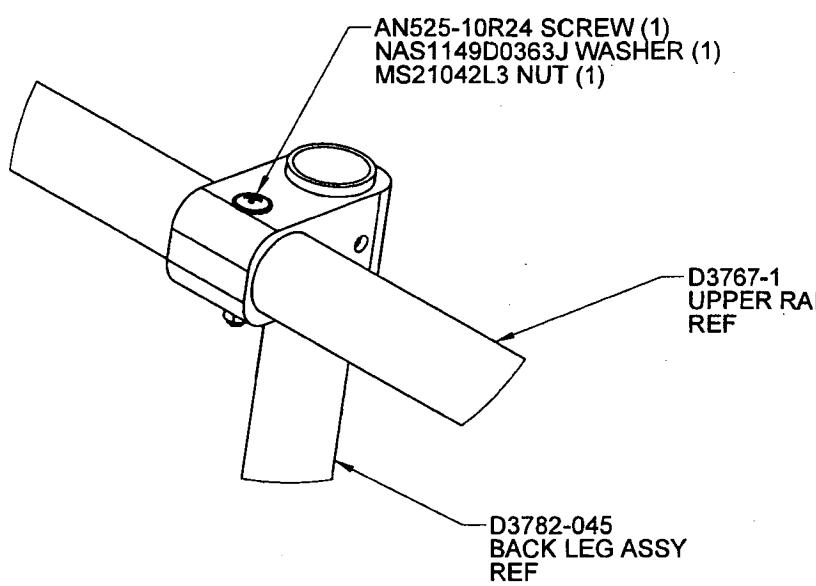
DESIGN	HS	DRAWING NO. D412-769-1 REV. B SHEET 2 OF 7	TITLE AFT FACING SEAT ASSY, LH NTS	SCALE 1:1 DATE 08.06.25	HAWKESBURY, ONTARIO, CANADA
DRAWN	HS				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					

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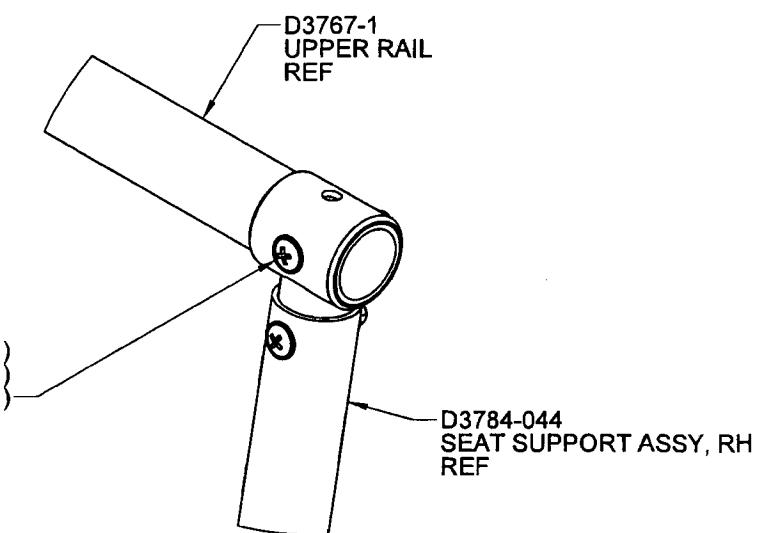
8 7 6 5 4 3 2 1

D

D



**DETAIL A D2-2**  
**UPPER RAIL TO BACK LEG ATTACHMENT**  
2 PL



**DETAIL B C1-2**  
**SEAT SUPPORT END ATTACHMENT**  
5 PL

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4250

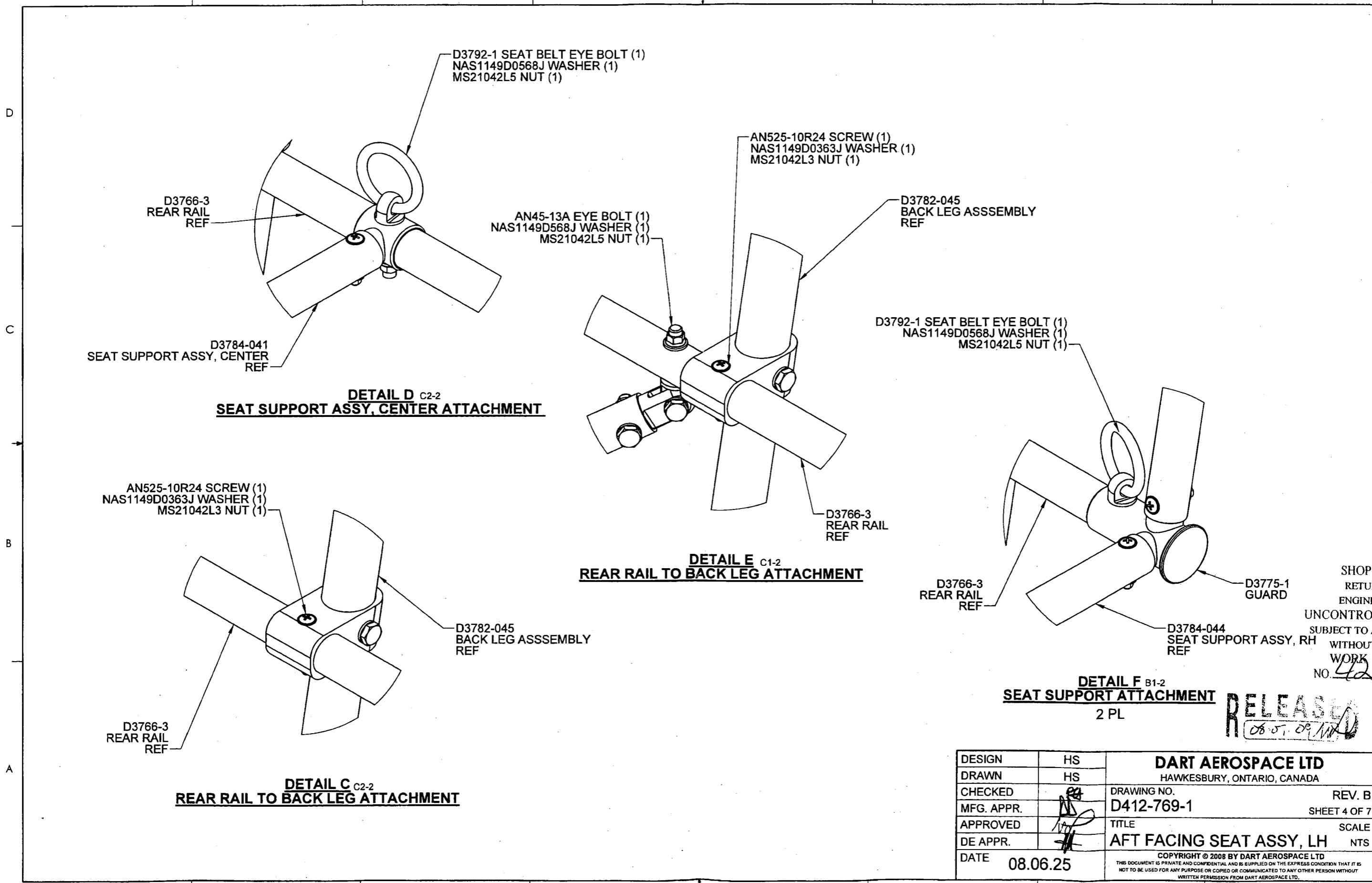
RELEASED  
07.07.09

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO.	REV. B
MFG. APPR.	N	D412-769-1	SHEET 3 OF 7
APPROVED	M	TITLE	SCALE
DE APPR.	S	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

C

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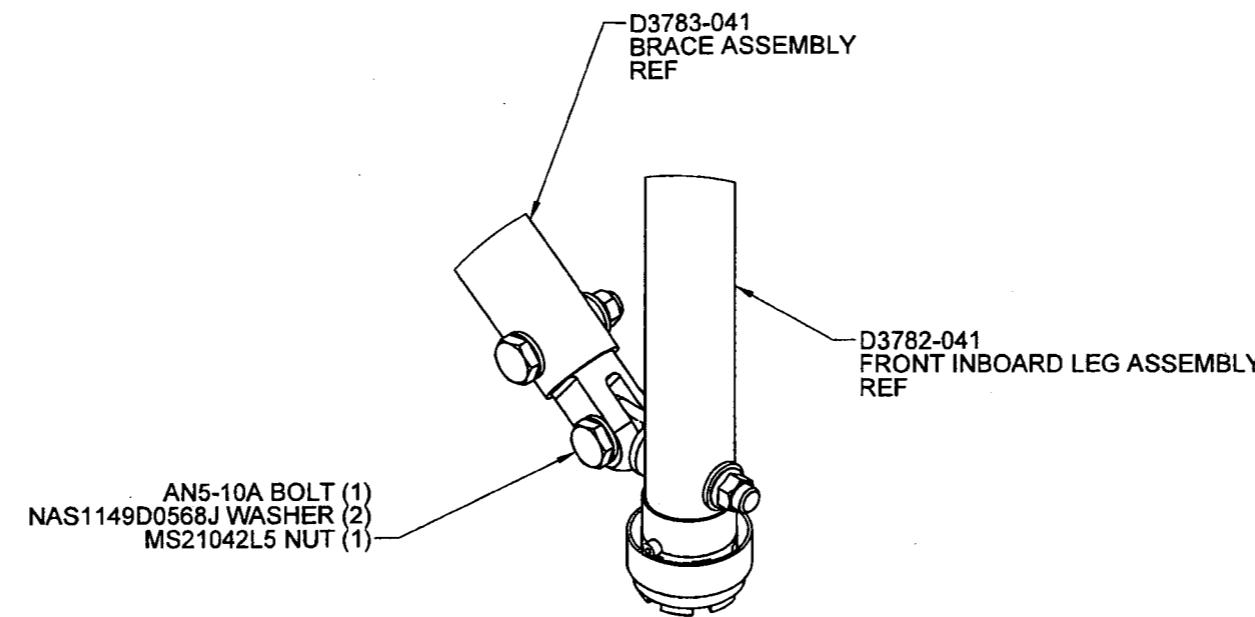
C

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B

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A



**DETAIL G<sub>B2-2</sub>**  
**BRACE ATTACHMENT**

6 PL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

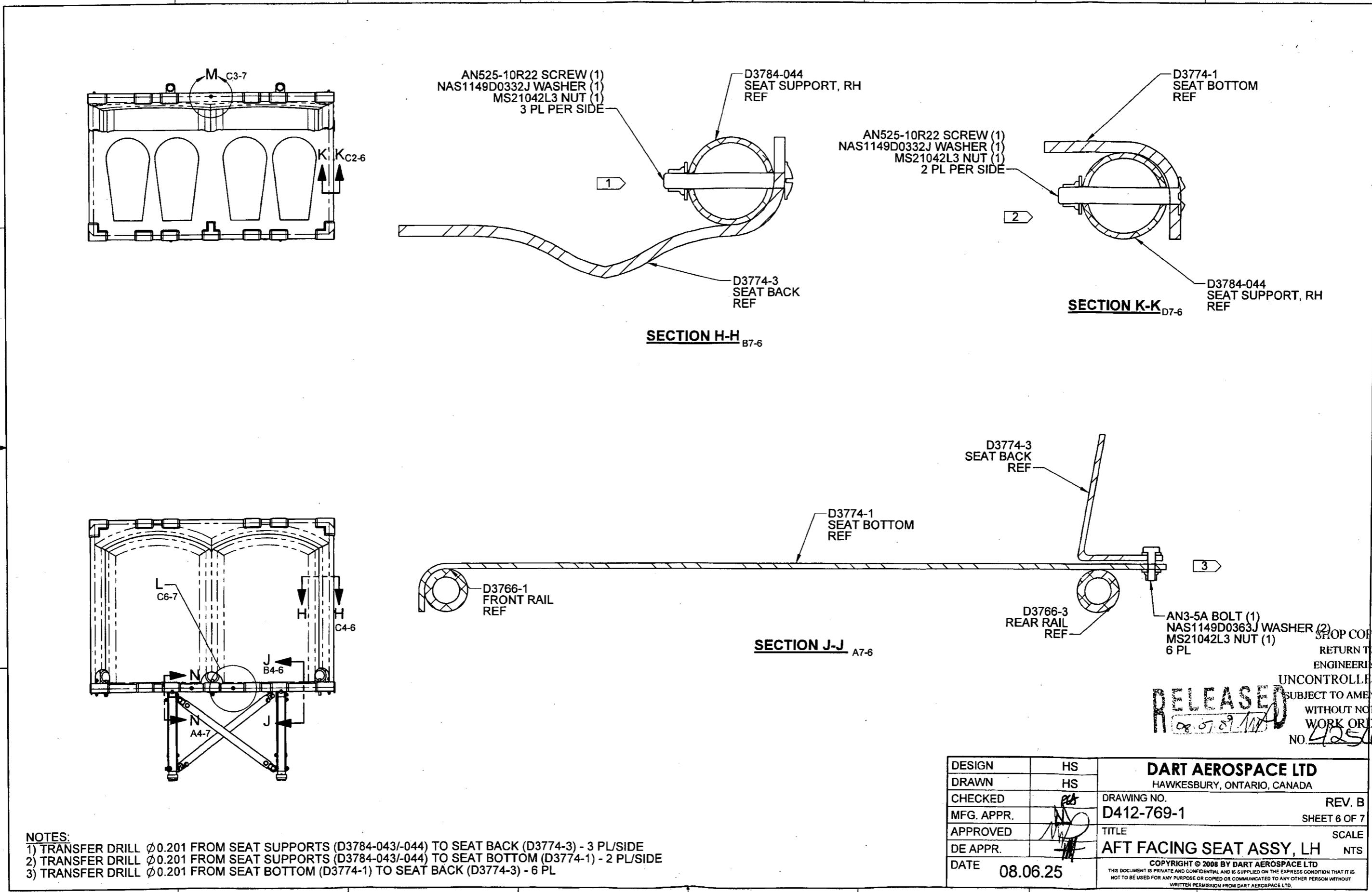
RELEASED  
08.07.07

NO. 42500

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>AS</i>	<b>D412-769-1</b>
APPROVED	<i>AS</i>	REV. B
DE APPR.	<i>AS</i>	SHEET 5 OF 7
DATE	08.06.25	TITLE
		SCALE
		NTS
		AFT FACING SEAT ASSY, LH

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8 7 6 5 4 3 2 1



DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKSLEY, ONTARIO, CANADA
CHECKED	ps	DRAWING NO.
MFG. APPR.	NO	D412-769-1
APPROVED	NO	REV. B
DE APPR.	NO	SHEET 6 OF 7
DATE	08.06.25	TITLE
		AFT FACING SEAT ASSY, LH
		NTS

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08.07.09  
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